



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4269-3 Job Sheet 189632



Part No: D4269-3

Job Qty: 5 pcs

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 2/28/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV A IPP Rev:A 11.04.04 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	5 pcs	2/28/19		0.00	1.31	Small Fab - 1			58 FEB 13 2019 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
110	QC 6	5 pcs	2/28/19		0.00	0.00	QC 6 - 38			DAS 40 9-89 / DAS 9-89
							QC 6 - 42			
							QC 6 - 9			
							QC 6 - 68			
							QC 6 - 61			
120	Handfinish - 1-1 Chemical-B4B	5 pcs	2/28/19		0.00	0.39	Handfinish - 1 - 1 - B4B			D.R 19/2/22
							Handfinish - 1 - 2 - B4B			
							Handfinish - 1 - 3 - B4B			
							Handfinish - 1 - 4 - B4B			
							Handfinish - 1 - 5 - B4B			
							Handfinish - 1 - 6 - B4B			
							Handfinish - 1 - 7 - B4B			
							Handfinish - 1 - 8 - B4B			
							Handfinish - 1 - 9 - B4B			
							Handfinish - 1 - 10 - B4B			
							Handfinish - 1 - 11 - B4B			
							Handfinish - 1 - 12 - B4B			
							Handfinish - 1 - 13 - B4B			
							Handfinish - 1 - 14 - B4B			

130	QC 7	5 pcs	2/28/19	0.00 0.00	Handfinish - 1 - 15 - B4B					
					Handfinish - 1 - 16 - B4B					
					Handfinish - 1 - 17 - B4B					
					Handfinish - 1 - 18 - B4B					
					Handfinish - 1 - 19 - B4B					
					Handfinish - 1 - 20 - B4B					
					Handfinish - 1 - 21 - B4B					
					Handfinish - 1 - 22 - B4B					
					QC 7 - 10					
					QC 7 - 13					
					QC 7 - 14					
					QC 7 - 15					
					QC 7 - 17					
					QC 7 - 18					
					QC 7 - 19					
					QC 7 - 2					
					QC 7 - 28					
					QC 7 - 3					
					QC 7 - 30					
					QC 7 - 34					
					QC 7 - 36					
QC 7 - 37										
QC 7 - 38										
QC 7 - 41										
QC 7 - 47										
QC 7 - 48										
QC 7 - 51										
QC 7 - 58										
QC 7 - 59										
QC 7 - 6										
QC 7 - 60										
QC 7 - 9										
QC 7 - 68										
QC 7 - 50										
QC 7 - 67										
140	Packaging 3-1 - Stock - B4B	5 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B					
					Packaging 3 - 2 - B4B					
					Packaging 3 - 3 - B4B					
					Packaging 3 - 4 - B4B					
					Packaging 3 - 5 - B4B					
					Packaging 3 - 6 - B4B					
					Packaging 3 - 7 - B4B					
					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
										Plex 1/29/19 9:20 AM Dart.Macdonald.Dara

DAS
 40
 9-89
 DAS
 9
 9-89

19.02.22

150 QC 21 - SA	5 pcs	2/28/19	0.00 0.00	Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B	5084	FEB 26 2019	
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
					DAS FEB 26 2019	21	9-56
				QC 21 - SA - 21			
				QC 21 - SA - 70			

94 FEB 26 2019

DAS FEB 26 2019
21 9-58

Part Op 100 - (Small Fab)
 Descriptions: 110 - (QC6- All purchased or subcontracted products)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - (QC7-Inspect Chemical Conversion Coat)
 140 - (Identify as per dwg & Stock Location: _____)
 150 - (QC21- Final Inspection - Work Order Release

Job BOM

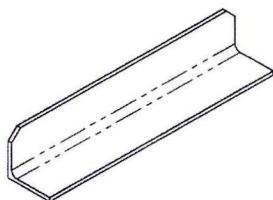
Part / Item	Component Name	Quantity	Operation	Container
M2024T3A.750X.750X.063W	Angle2024T3511 .750 x .750 x .063w	1.9300 ft (.386 ea)	100-Small Fab - 1	5049805

Job Allocations

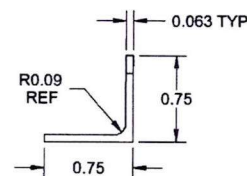
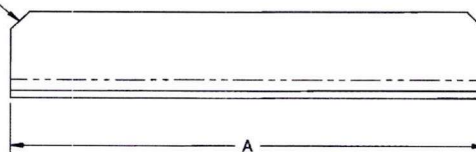
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	M2024T3A.750X.750X.063W	2	12	0

Part Specifications

Specifications could not be found.



0.16 x 45°
CHAMFER
2 PL



D4269-X
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

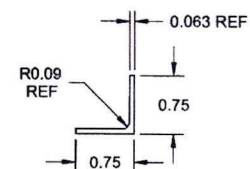
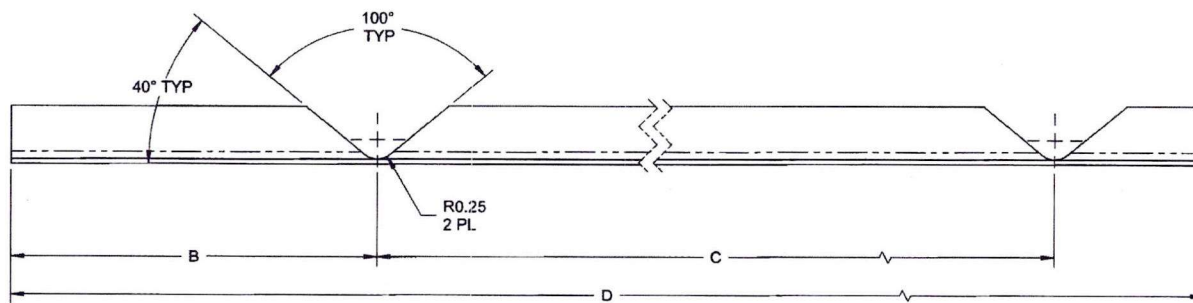
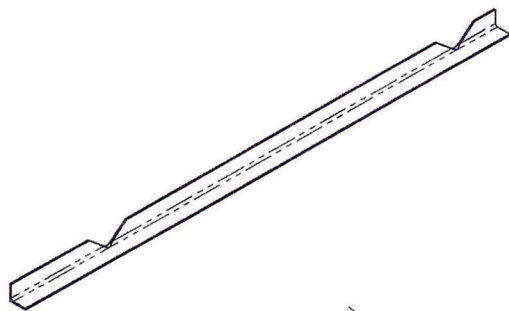
PART NUMBER	DESCRIPTION	EA20469-Y	A	WEIGHT
D4269-1	ANGLE	EA20469-33	4.03	0.04
D4269-3	ANGLE	EA20469-30	4.63	0.04

RELEASED
2011-04-06
WNN

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: SEE TABLE

A	NEW ISSUE	RF	10.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4269	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4269-Z
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-Y)

PART NUMBER	DESCRIPTION	EA20469-Y	B	C	D	WEIGHT
D4269-5	ANGLE	EA20469-29	4.66	16.69	23.25	0.21
D4269-7	ANGLE	EA20469-32	2.28	16.5	22.03	0.19

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3AH0.75XW0.75XT0.063R0.090
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) WEIGHT: SEE TABLE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4269	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

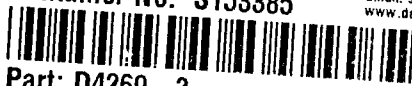
Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					



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Container No: S153385



Part: D4269-3

Job No: 189632

Serial No/Batch: S153385

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/13/19